



PRESSING
INSTRUCTION
USERS OF THE PRODUCT SERVICE MANUAL

PRESSING INSTUCTION

Technical parameter



The press is small in volume, light in weight, no oil leaking, and convenient for use in the glove box.



Integrated motherboard structure, oil pool, mainboard, cylinder, in one body, no sealing connection, reduce oil leakage.

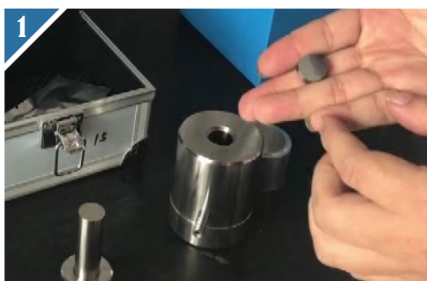


The pressure gauge can be fitted with digital display, the pressure control is accurate, and the pressure display accuracy is 0.01 Mpa.

Model	5 T	12 T	15 T	24 T
Pressure	0-5T	0-12T	0-15T	0-24T
Diameter	Φ45mm	Φ70mm	Φ80mm	Φ95mm
Piston stroke	30mm		30mm	30mm
Columns	2	2	4	4
Distance	96×130mm		80×140mm	80×150mm
Dimension	225×155×380mm		245×175×390mm	245×175×415mm
Weight	28kg	38kg	40kg	42kg

Model	30 T	40 T	60 T
Pressure	0-30T	0-40T	0-60T
Diameter	Φ110mm	Φ130mm	Φ150mm
Piston stroke	40mm	50mm	50mm
Columns	4	4	4
Distance	92×160mm	115×185mm	185×250mm
Dimension	275×195×420mm	295×215×500mm	405×240×565mm
Weight	56kg	75kg	120kg

Operation steps



1 Put the die sleeve and the bottom of the mold to be assembled, put the die piece.



2 Put the sample in the mold and then smooth the powder.



3 Put the mold into the center of the press and tighten the handwheel.



4 Tighten the oil drain.



5 The shaking pressure begins to pressurize and press to the required pressure.



6 Release the oil valve.



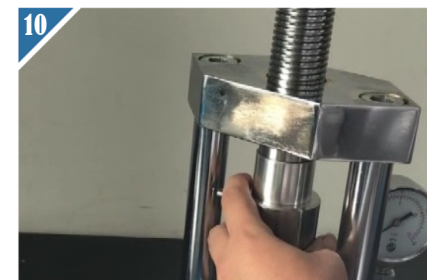
7 Remove the mold.



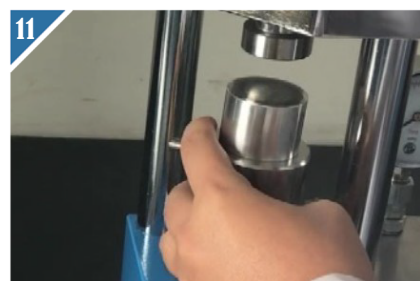
8 Remove the bottom of the mold and install the mold release tool.



9 Put the assembled mold into the press.



10 The sample of the mold is ejected with the screw of the press.

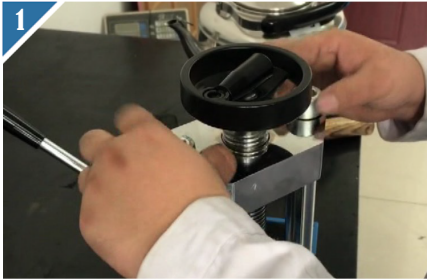


11 Take off the mould.



12 Remove the sample from the mold.

Replace rubber ring



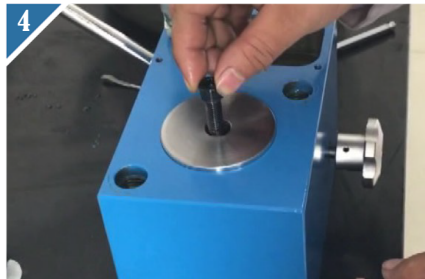
1 Loosen the fastening screws on the upper plate and remove the upper plate.



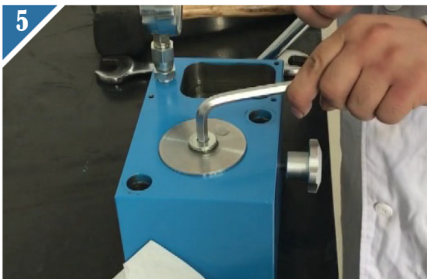
2 Remove the column and remove the top cap of the cylinder.



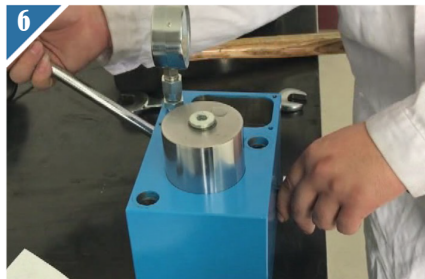
3 Release the master cylinder lock nut with 8mm hexagonal wrench.



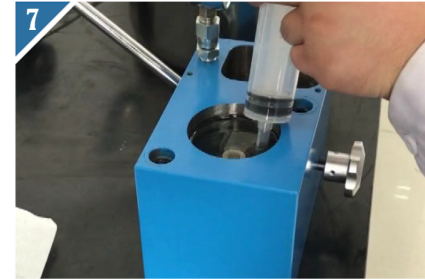
4 Unload the spring screws in the oil cylinder



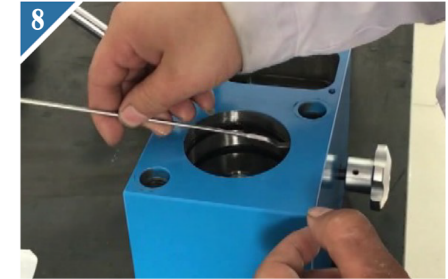
5 Install a large cylinder lock mother.



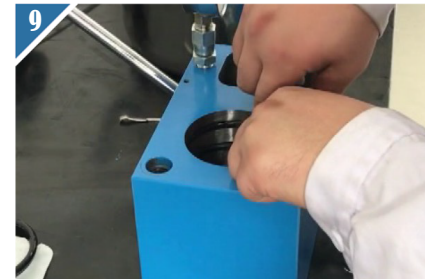
6 Tighten up the valve stem and shake the pressure handle to push out the large cylinder with hydraulic oil.



7 Remove the hydraulic oil from the cylinder.



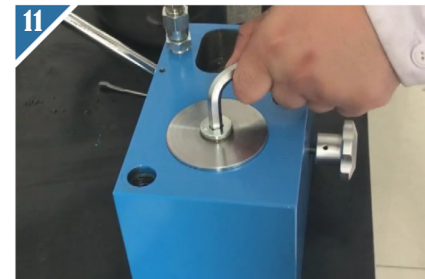
8 Remove the sealing ring from the cylinder.



9 Replace the new sealing ring.



10 Use a rubber hammer to blow the big oil cylinder back to the bottom .



11 Tighten the spring screw and the large oil cylinder to seal the lock.



12 Restore column and upper plate.

Replacement parts



1 Unload the pressurized press.



2 Take out the guide sleeve.



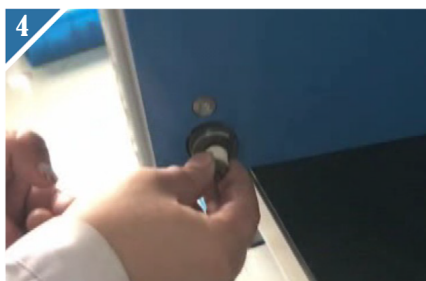
7 Separate the pressure gauge from the pressure gauge column.



8 Remove the pointer pressure gauge.



3 With the special board release plunger.



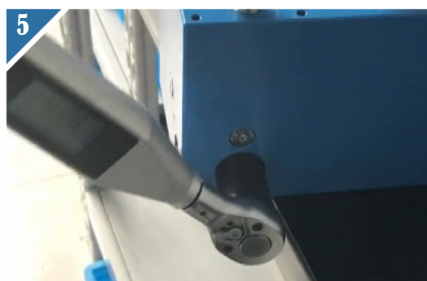
4 For a new small plug



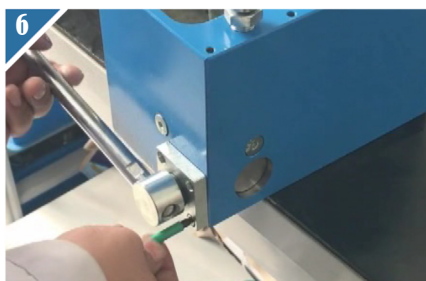
9 Remove the pressure gauge connection post .



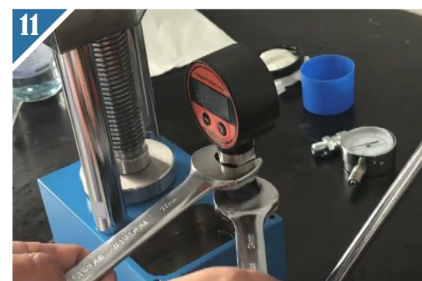
10 Install digital meter special pressure gauge connection column.



5 Close the small plunger with a special board.



6 Restore guide sleeve and press handle .

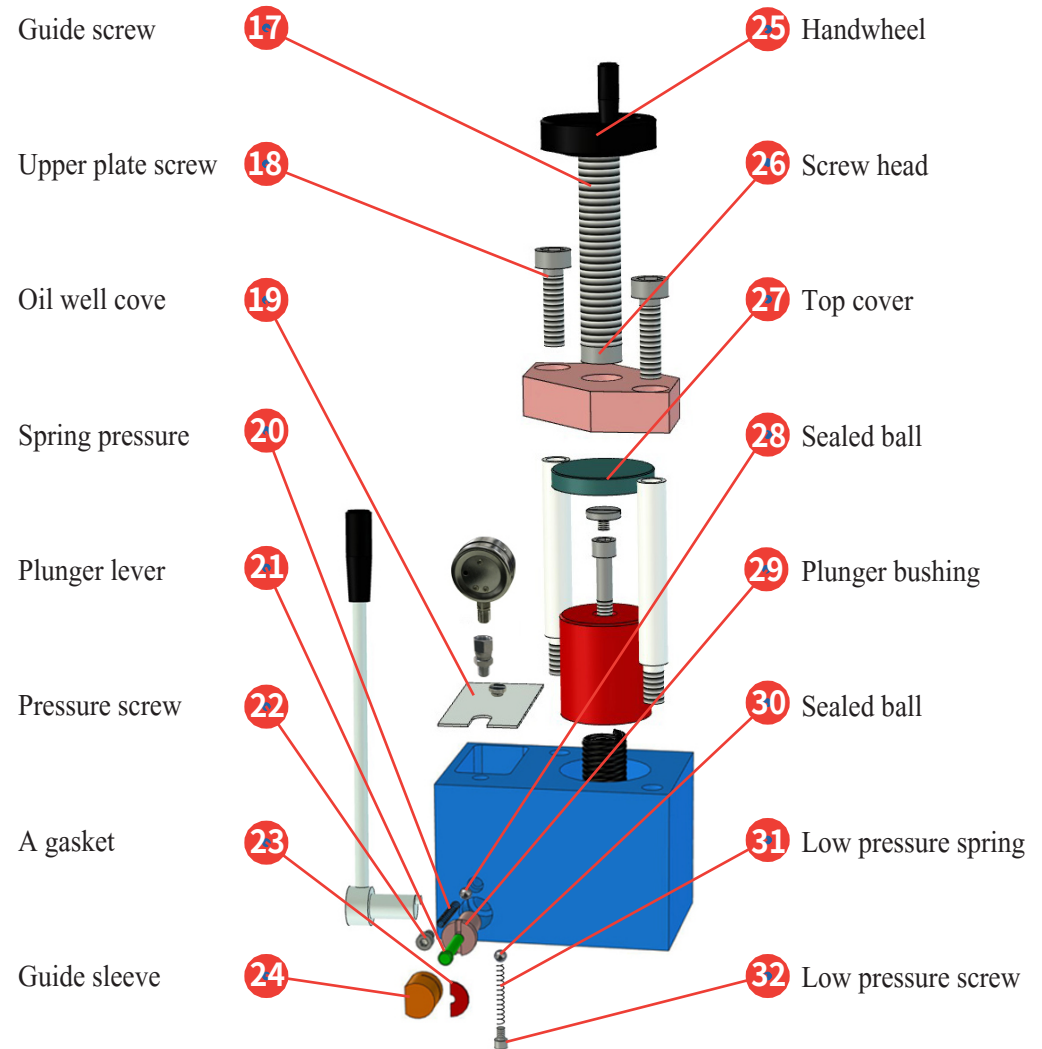
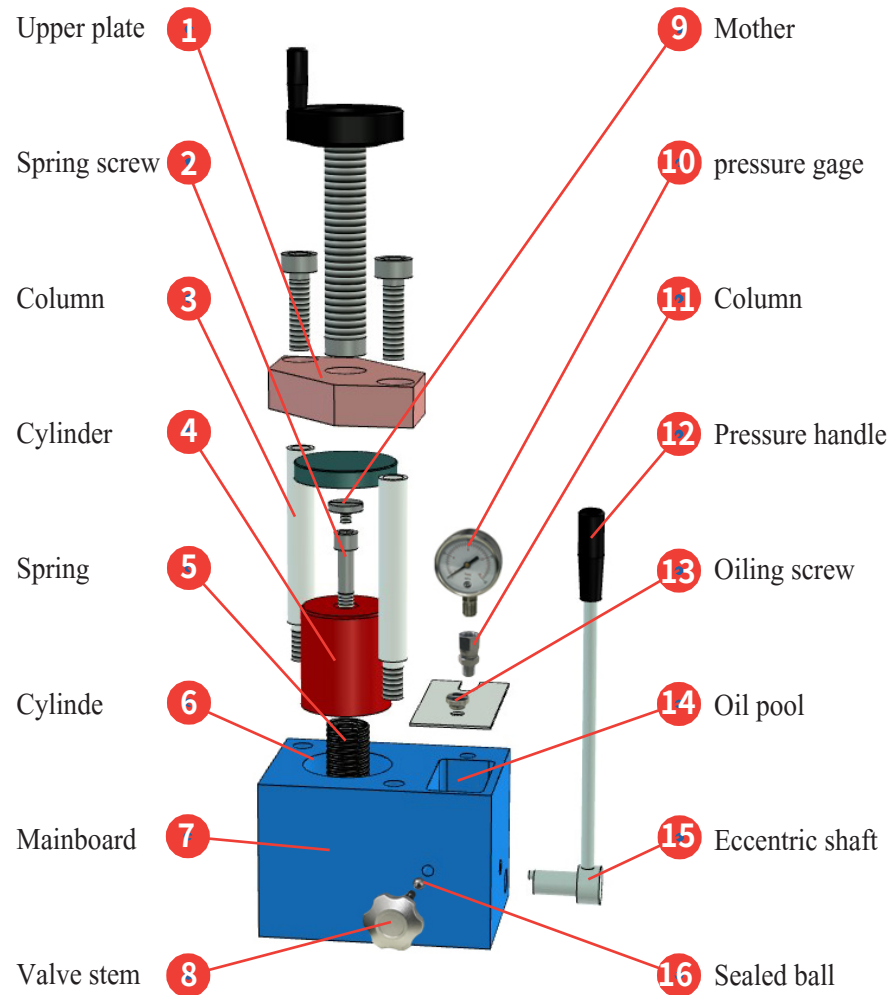


11 The digital meter and special pressure gauge connection column fastened together.



12 Use a thin plate to open the ball of a one-way valve and shake the press to release the gas.

Decomposition structure diagram



Common no - pressure problems

There is no top below the lead screw 17, or something on the top is softer, deformed when pressurized, so the pressure gauge shows no pressure.

1

The injection screw 13 does not loosen, causing the hydraulic oil not to go down, the cylinder can not absorb the oil, so no pressure.

2

Oil drain valve stem 8 without tight die, hydraulic oil back to the oil tank pressure cannot be saved, so no pressure.

3

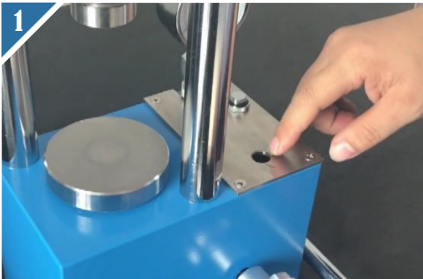
The hydraulic oil in the oil pool 14 is too low and the system can't absorb the oil to make the tablet press pressure free.

4

The oil inside the inlet, with a thin screwdriver open top ball one-way valve. In the other hand shake the pressure to 12, the air, the equipment becomes normal.

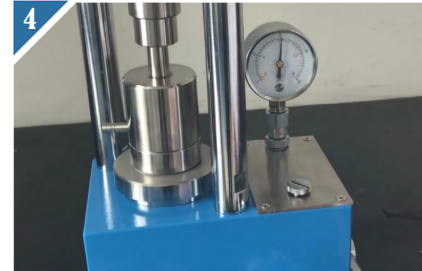
5

Matters needing attention



1: oil pool does not suck oil

In order to prevent oil leakage , the oil hole screws are tightly screwed, but the oil tank seal is very good , the cylinder can not be sucked in the hydraulic oil can not be properly pressurized, the normal use of the screw should be released.



4: Die overpressure

When pressure is pressed, the mold must be placed in the center of the pressing machine. It can not exceed the maximum pressure that the mold can bear , so as to avoid the deformation of the mold.



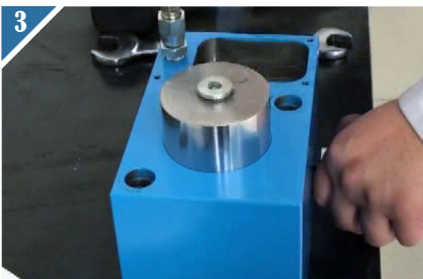
2: the intake of oil is not up to pressure

The oil inside the inlet, with a thin screwdriver open top ball one-way valve. In the other hand shake the pressure to 12, the air, the equipment becomes normal.



5: the deformation of the screw

When pressing , the screw thread must all enter the upper plate, and can not only connect a few buckles to prevent the screw thread deformation from using.



3 : Tension spring deformation

Cylinder 4 does not exceed the specified stroke will cause tension spring 5 deformation , the cylinder can not return to the initial position. Use pay attention to the height of cylinder 4.



6: replacement of hydraulic oil

It is appropriate for the press to use a clean No. 46 anti-wear hydraulic oil. If the color is black or more particles are needed, it needs to be replaced in time.